



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2571**Job Sheet 211486****Part No:** D2571**Job Qty:** 10 pcs**Part Name:** Saddle, Fwd, Out**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/17/20**Job Tracking No:****Due Date:** 8/14/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV F IPP: I 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	10 pcs	8/13/20		0.00	0.00	HAAS - 1	DAS 52 9-89	20/8/21
							HAAS - 2		
							HAAS - 3		
							HAAS - 4	DAS 52 9-89	
100	HAAS 4 Axis - B4B	10 pcs	8/13/20		1.00	16.13	HAAS - 1 - B4B	DAS 52 9-89	20/08/25
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B	DAS 52 9-89	
110	Conventional Mill - 1 - B4B	10 pcs	8/13/20		0.00	1.54	Conventional Mill - 1 - B4B	DAS 52 9-89	20/08/25
							Conventional Mill - 2 - B4B		
120	QC 2	10 pcs	8/13/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		

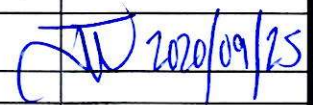
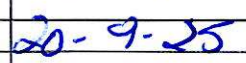
**Container No:** S295422**Part:** D2571**Job No:** 211486**Serial No/Batch:** S295422**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
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Date: 08/21/20

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						QC 2 - 50	
						QC 2 - 51	DAS
						QC 2 - 52	52
						QC 2 - 57	9-89
						QC 2 - 62	10/08/25
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 2 - 83	
130 QC 8	10 pcs	8/13/20	0.00	0.00		QC 8 - 12	
						QC 8 - 14	ml 20/08/31
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						QC 8 - 66	
						QC 8 - 73	
						QC 8 - 82	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	8/13/20	0.00	1.25		Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 -	

				B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White Gl(A)- B4B	10 pcs	8/14/20	0.00 1.25	Powdercoat - 1 - B4B	  
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
160 QC 3	10 pcs	8/14/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	SEP 2 5 2020
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
170 Packaging 3-1 - Stock - B4B	10 pcs	8/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	 

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
180 QC 21 - SA	10 pcs	8/14/20	0.00	0.00	QC 21 - SA - 21	DAS 21 SEP 29 2020
					QC 21 - SA - 70	9-89
					QC 21 - SA - 9	
					QC 21 - SA - 77	

Part Op **100** - (HAAS CNC vertical machine #1) Program Batch No. 5295422 Double check by: JD 1-Machine Step No 1
 Descriptions: per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per
 attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect
110 - (Manufacture as per dwg) Machine keyway as per dwg D2571 & D2572
120 - (QC2- Inspect parts off machine FAI/FAIB) Inspect on CMM as per folio CMMA022.
130 - (QC8- Inspect parts - second check)
140 - (Chemical Conversion Coat per QSI005 4.1)
150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ FINISH TIME: _____
160 - (QC3- Inspect Part Finish)
170 - (Identify as per dwg & Stock Location: _____)
180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	10 pcs (1 ea)	90-Machining - Issue SN	5292239

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-007	10	8	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle, Fwd Outboard	0.438Inches + 0.005 - 0.000	0.443 0.438		
2	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
3	Saddle, Fwd Outboard	3.495Inches + 0.010 - 0.000	3.505 3.495		
4	Saddle, Fwd Outboard	1.745Inches + 0.010 - 0.000	1.755 1.745		
5	Saddle, Fwd Outboard	7.990Inches + 0.020 - 0.000	8.010 7.990		
6	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
7	Saddle, Fwd Outboard	0.257Inches + 0.005 - 0.000	0.262 0.257		
8	Saddle, Fwd Outboard	0.375Inches + 0.005 - 0.000	0.380 0.375		
9	Saddle, Fwd Outboard	0.490Inches + 0.020 - 0.000	0.510 0.490		
10	Saddle, Fwd Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
11	Saddle, Fwd Outboard	0.558Inches + 0.020 - 0.000	0.578 0.558		
12	Saddle, Fwd Outboard	1.174Inches + 0.010 - 0.000	1.184 1.174		
13	Saddle, Fwd Outboard	1.490Inches + 0.010 - 0.000	1.500 1.490		
14	Saddle, Fwd Outboard	2.495Inches + 0.010 - 0.000	2.505 2.495		
15	Saddle, Fwd Outboard	3.869Inches + 0.010 - 0.000	3.879 3.869		
16	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
17	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
18	Saddle, Fwd Outboard	0.240Inches + 0.020 - 0.000	0.260 0.240		
19	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
20	Saddle, Fwd Outboard	0.178Inches + 0.020 - 0.000	0.198 0.178		
21	Saddle, Fwd Outboard	2.940Inches + 0.040 - 0.000	2.980 2.940		
22	Saddle, Fwd Outboard	0.230Inches + 0.020 - 0.000	0.250 0.230		
23	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		
24	Saddle, Fwd Outboard	0.308Inches + 0.005 - 0.000	0.313 0.308		
25	Saddle, Fwd Outboard	0.760Inches + 0.005 - 0.000	0.765 0.760		
26	Saddle, Fwd Outboard	0.352Inches + 0.020 - 0.000	0.372 0.352		
27	Saddle, Fwd Outboard	0.470Inches + 0.060 - 0.000	0.530 0.470		
28	Saddle, Fwd Outboard	0.615Inches + 0.020 - 0.000	0.635 0.615		
29	Saddle, Fwd Outboard	0.053Inches + 0.020 - 0.000	0.073 0.053		
30	Saddle, Fwd Outboard	0.240Inches + 0.020 - 0.000	0.260 0.240		
31	Saddle, Fwd Outboard	1.375Inches + 0.020 - 0.000	1.395 1.375		
32	Saddle, Fwd Outboard	0.115Inches + 0.020 - 0.000	0.135 0.115		

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7/17/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

33	Saddle, Fwd Outboard	0.240Inches	+ 0.040	0.280
			- 0.000	0.240
34	Saddle, Fwd Outboard	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
35	Saddle, Fwd Outboard	2.000Inches	+ 0.020	2.020
			- 0.000	2.000
36	Saddle, Fwd Outboard	0.023Inches	+ 0.020	0.043
			- 0.000	0.023

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DART AEROSPACE LTD	Work Order: 211486
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.501	0.501	0.502	0.501		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.501	0.500	0.501		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.569	0.567	0.569		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.128	0.126	0.126	0.125		
R	0.240	0.260		0.253	0.254	0.254	0.253		
S	0.115	0.135		0.131	0.131	0.132	0.134		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		0.247	0.245	0.245	0.245		
W	0.115	0.135		0.124	0.126	0.129	0.1275		
X	0.308	0.313		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.3655	0.3645	0.369		
AA	0.470	0.530		0.505	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.625		
AC	0.053	0.073		0.060	0.060	0.060	0.060		
AD	0.240	0.260		0.253	0.254	0.254	0.255		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.254	0.255	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

Measured by: <u>52 / DTP</u>	Audited by: <u>mf</u>
Date: <u>9-89 20-08-23</u>	Date: <u>20/08/13</u>

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 211486
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.438	0.443		0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.499	0.501	0.501	0.500		
G	0.257	0.262		0.258	0.258	0.258	0.258		
H	0.375	0.380		0.376	0.376	0.376	0.376		
I	0.490	0.510		0.500	0.500	0.500	0.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.568	0.567	0.567	0.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		2.874	2.874	2.874	2.874		
P	0.115	0.135		0.135	0.135	0.135	0.135		
Q	0.115	0.135		0.1245	0.125	0.125	0.124		
R	0.240	0.260		0.252	0.253	0.254	0.254		
S	0.115	0.135		0.132	0.134	0.134	0.134		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.246	0.249	0.245	0.244		
W	0.115	0.135		0.127	0.129	0.126	0.128		
X	0.308	0.313		0.312	0.311	0.311	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.366	0.371	0.371	0.368		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.625	0.625	0.626		
AC	0.053	0.073		0.060	0.060	0.060	0.060		
AD	0.240	0.260		0.255	0.259	0.255	0.253		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.130	0.130	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.255	0.260	0.255	0.256		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		

Accept/Reject

DAS

52

9-89

Measured by: <u>DJP</u>	Date: <u>20-08-24</u>
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Audited by: <u>Jul</u>	Date: <u>26/08/31</u>
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Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD	Work Order: 211486
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. F	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	X	X		
A	0.438	0.443		0.438	0.438				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.002	8.002				
F	0.490	0.510		0.500	0.500				
G	0.257	0.262		0.258	0.258				
H	0.375	0.380		0.376	0.376				
I	0.490	0.510		0.501	0.500				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		0.567	0.568				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		0.135	0.135				
Q	0.115	0.135		0.125	0.125				
R	0.240	0.260		0.254	0.254				
S	0.115	0.135		0.134	0.134				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		0.244	0.245				
W	0.115	0.135		0.126	0.128				
X	0.308	0.313		0.315	0.310				
Y	0.760	0.765		0.760	0.760				
Z	0.352	0.372		0.369	0.369				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.626	0.626				
AC	0.053	0.073		0.060	0.060				
AD	0.240	0.260		0.255	0.255				
AE	1.375	1.395		1.385	1.385				
AF	0.115	0.135		0.130	0.130				
AG	0.240	0.280		0.250	0.250				
AH	0.240	0.260		0.254	0.256				
AI	2.000	2.020		2.000	2.000				
AJ	0.023	0.043		0.033	0.033				
Accept/Reject									

Measured by: 52
Date: 9-89 20/08/25

Audited by: [Signature]
Date: 20/08/13

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition			Completed By		
					Lead hand / Supervisor		
					QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
Other/Details:							